Work Order Wednesday, May	r ID 69760 18, 2011 1:01:29 PM								Page 1
Revision ID:	O3536-39 Gasket		A	Accept				Setup Sta	
Start Date: 5 Required Date: 5 Reference:	5/18/2011 Start Qty 5/23/2011 Req'd Qt		(/	Cust Item II Customer:	D :			
	Process Plan:	//	Pate:/ <i> -05- 8</i> Pate:	Tooling: SPC (Y/N):	Da	te:	_	Run Sta Sta	
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool # Plan		Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A			•					
Waterjet FLOW CNC Waterjet	*	TER JET Memo 1-Cut as per Dwg Deburr if necessa		0.00 0.00 ★ □Prog Rev:	A □2-		Bu	- <- >4	€
QC Quality Control		et parts off machi	ne FAI/FAIB	0.00			KB U	- 5- 54	† ————
120 	QC8- Inspec	ct parts - second o	check	0.00 S w/c	5-174		(au	Area (

Quality Control

W/O:				N	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDUR	E CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										:	
Part No		PAR #:	Fau	lt Ca	tegory:	NCF	l: Yes N	lo DQ	A :	Date:	
	R	esolution:	Disp	osit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:		\	WORK	OR	DER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Initi Chief		Corrective Action Section Action Description	n B	Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
			Oriteil	Eng	Chief Eng		Date				
								:			
										:	
	1										

NOTE: Date & initial all entries

Work Order ID 69760



Page 2

Wednesday, May 18, 2011 1:01:29 PM

Item ID:

D3536-39

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 5/23/2011

Gasket

5/18/2011

OC:

Start Oty: 16.00 Reg'd Otv: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run



Sequence ID/ Operation Set Un/ **Tool ID** Tool # Plan Work Center ID Description Run Hours Code

Date:

Identify as per dwg & Stock Location:

0.00

Reject

Reject Insp.

130

Packaging

Memo

0.00

Oty

Accept

Oty

Number

Stamp

Packaging

140

OC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- MF

Quality Control

W/O:				WOR	K ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE	CHANG	E		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										······································	
				· · · · · · · · · · · · · · · · · · ·				··			
Part No		PAR #:									
	Res	solution:								Date:	
NCR:			WORK	ORDER	NON-CONFORM	ANCE	(NCR))			
DATE STEP		Description of NC	Initia			tion B	Sign &		cation		Approval
		Section A	Chief Er	ng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
						1					
										·	
											:

Picklist Print

Wednesday, May 18, 2011 1:01:35 PM

Work Order ID: 69760

Parent Item:

D3536-39

Parent Item Name: Gasket



Start Date: 5/18/2011

Required Date: 5/23/2011

Page 1

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	_	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	221.1800	0.7534	13.39378			
												- Sty	

NEOPRENE SHEET 0.063

Location Loc Qty Loc Code 221.18 MAT052 117295 221.18



W/O:				W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE	СН	CHANGE By C				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Faul	t Cat	egory:	_ NCF	: Yes I	No DQ	A:	Date:	
1	R	esolution:	Disp	ositi	on:	_ QA:	N/C Clo	sed:		Date:	
NCR:			NORK	ORI	DER NON-CONFORMA	NCE	(NCR)			
DATE STEP		Description of NC Section A	Corrective Action Init al Action Descript			Section B			cation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief		Chief Eng		Date	3601		Office Eng	QO Mapeciol
								į			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	49760
Description: Gasket	Part Number:	D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST											
	X	First Article	F	Prototyp	e						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
35.71	+/-0.030	35.71			T BUIL						
32.78	+/-0.030	35.78			1						
29.28	+/-0.030	ે છેલે. એ	L		7						
25.78	+/-0.030	25.78	v		7						
23.25	+/-0.030	23.25	7		1						
19.75	+/-0.030	19.74			7						
17.75	+/-0.030	17.74			T						
14.25	+/-0.030	14.76	10		T						
9.50	+/-0.030	9,50	7		7						
4.75	+/-0.030	4.75	x		7						
5.00	+/-0.030	5,00	>		7						
9.00	+/-0.030	9.00	8		1						
0.30	+/-0.030	304	×		N BOD						
0.30	+/-0.030	-303	7		V						
1.88	+/-0.030	1885	k		V						
Ø0.19	+0.005/-0.001	190	×		V						
0.063	+/-0.010	رمادا	>		ŭ						

Measured by: 18	Audited by:	Prototype Approval:	N/A
Date: 11-5-24	Date: 11/05/74	Date:	N/A

Rev	Date	Change	Revised by	Approxed
Α	07.03.14	New Issue	KJ/JLM OK	

Dart Aerospace Ltd

W/O:	/o: WORK ORDER CH									
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		ž.								
								į		
Part No	:	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	\ :	Date:	
	Resolution: Disposition:				QA	: N/C CI	osed:		Date:	
NCR:		V	WORK OR	DER NON-CONFO	RMANCE	(NCF	?)			
	Description of NC Corrective Action				Section B	Verific	Verification App		Approval	
DATE STEP		Section A	Initial Action Descri Chief Eng Chief Eng		tion Sign & Date		Section		Chief Eng	QC Inspector
										:
									·	
									i i	
ı										

B.02.12

B

DART

AEROSPACE PORT HADLOCK,

USA,

R C.

£

DRAWING NO.

SHEET 1 OF 6

SCALE 1:10

06.

.10.25

GASKET

06.10.25

NEW ISSUE

26.65 23,15 21.15 17.65 9.15 - 0.90 - 5.65 1.89 3.90 DETAIL A #0.19 (TYP 3 PLS)

D3536-11 GASKET

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. GQZGO

32.90	٠.
29.40	
27.40	
23.90	
18.98	
14.07	
9.15	0.90
5.65	
<u></u>	- 1.89
DETAIL A 3.90 3.90	<u> </u>
. /	,
(TYP 4 PLS) 14.00 20.00	
(TYP 4 PLS) 20.00	

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

, ,	
32.90	•
29.40	
27.40	
23.90	
18.98	
14.07	
9.15	0.90
5.65	
	1
Q	- 1.89
	
DETAIL A - 3.90 3.90	- - '
(TYP 4 PLS) 20.00 14.00	
(TYP 4 PLS) 20.00	
<u> D3536-13 GASKET</u>	

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. PURPOSE 유 COPIED

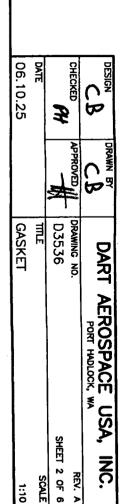
붚

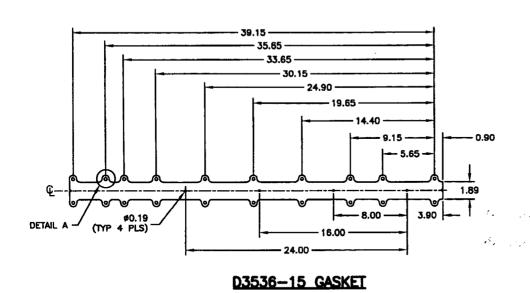
DOCUMENT

ᄶ

W/O:				WORK ORDER C	CHANGES		,			
DATE	STEP	PROC	EDURE	CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:			
Part No	:	PAR #:	_ Faul	Category:	NCR:	: Yes N	o DQA:		_ Date: _	
	R	esolution:	_ Disp	osition:	QA: I	N/C Clos	sed:		Date:	
NCR:		W	ORK	ORDER NON-CON	FORMANCE	(NCR)				
DATE	STED	Description of NC		Corrective Action		0: 0	Verifica	tion	Approval	Approval
DATE	STEP	Description of NC Section A	Initi Chief E	al Action Desc	cription	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Description of NC Section A		al Action Desc	cription					Approval QC Inspector
DATE	STEP	Section A		al Action Desc	cription					Approval QC Inspector

NOTE: Date & initial all entries





07.02.12

		32.70			1
		27.25			
	21.80	 			}
	10.90			_	0.90
2.00	6.00 - 8.00 - 16.	00			1.89 1.19 (P 4 PLS)
	ſ	3536-21	GASKE	[

붚S

DOCUMENT

Ŋ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

욹

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.06:
- FINISH: NONE
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** DATE **STEP** PROCEDURE CHANGE Bv Chief Eng / Prod Mgr Date Qtv QC Inspector Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR:

		Description of NC		Corrective Action Section B		Verification	Ammuoval	Annroval
DATE	STEP	Section A	Init Chief	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
1								
	1							

3

DRAWING NO.

SHEET

3 OF

1:10

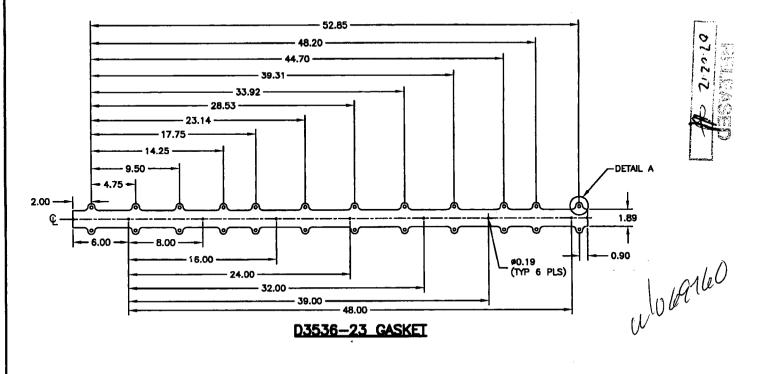
DART

AEROSPACE PORT HADLOCK.

NC.

06.10.25

GASKET



101172

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

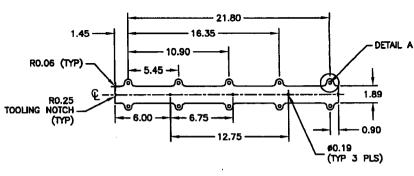
3) PART IS SYMMETRICAL ABOUT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

Copyright © 2006 by DART AEROSPACE USA, INC. SONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED NICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.
--

봀

DOCUMENT

S

PRIVATE AND COMMUN

W/O:				WORK ORDER CH	IANGES				
DATE	STEP	PRO	CEDURE	CHANGE	Ву	y [Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Faul	t Category:	NCR: \	res No	DQA:		
		esolution:					•		
NCR:		V	NORK	ORDER NON-CONF	ORMANCE (N	ICR)			
DATE	STEP	Description of NC	Initie	Corrective Action Action Descri	Section B	ign &	Verification	Approval	Approval
		Section A	Chief E	ing Chief Eng		Date	Section C	Chief Eng	QC Inspector
		1							

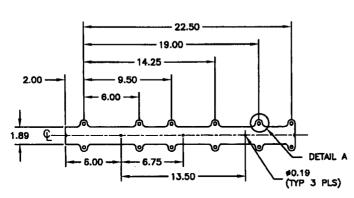
07.02.12



NO.

4 OF 6

1:10



D3536-31 GASKET

21.00 15.25 2.00 ---9.50 6.00 --1.89 6.00 DETAIL A #0.19 (TYP 3 PLS) D3536-33 GASKET

24.50

23.25 19.75

- 17.75 2.00 -4.75 Œ. 1.89

D3536-35 GASKET

#0.19 (TYP 2 PLS)

DETAIL A

拭

DOCUMENT

ĸ

Copyright © 2006 by DART AEROSPACE USA, INC.
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

욹

COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT €
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart	Aeros	pace	Ltd

W/O:			1	WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE		HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
98		,							
Part No	:	PAR #:	Fault Ca	ategory:	NCR: Yes	No DC	A:	_ Date: _	
	R	esolution:			- · ·			Date: _	
NCR:		\	WORK OF	RDER NON-CONF		R)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descr	Section B Sign		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Date		tion C	Chief Eng	QC Inspector
					·			·	
-							·-		

		·							
								,	

Dart Aerospace Ltd

W/O:				WORK ORDER CHA	ANGES				
DATE	STEP	PRO	CEDURE	CHANGE	E	Ву (Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,	
•							į		
Part No	:	PAR #:	Fault	Category:	NCR:	Yes No	DQA:	Date: _	
	R	esolution:					ed:	Date: _	
NCR:		•	WORK O	RDER NON-CONFO	RMANCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verification	Approval	Approval
		Section A	Chief En	g Chief Eng		Date	Section C	Chief Eng	QC inspector
:									

oran A	
erana.	

D3536-41 GASKET

≠0.19 (TYP 2 PLS)

1.88

- 27.98 25.08

18.50 -

15.00

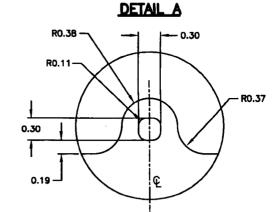
2.00 -

4.00 -

DETAIL A

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



4 0	80	PORT HADLOCK, WA	SA, INC.
CHECKED	APPROVED //	DRAWING NO.	REV. A
PA PA	#	D3536	SHEET 6 OF 6
DATE		TITLE THE STATE OF	SCALE
06.10.25		GASKET	1:10

뒾 DOCUMENT S Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹 COPIED

Dart Aerospa	ce	Ltd
--------------	----	-----

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE	CHANGE By			ate G	Approval Chief Eng / Prod Mgr	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			ĺ							
						ļ				
			-					-		
						<u> </u>				
Part No: PAR #:		Fault	Category:	NCR: Ye	es No	DQA:		Date:		
Resolution:		Dispo	sition:	QA: N/C	QA: N/C Closed:				Date:	
NCR:		V	VORK C	RDER NON-CONFO	ORMANCE (N	CR)				
DATE	STEP	Description of NC Section A	Initia		Section B otion Sig	Verificati Section (Approval Chief Eng	Approval QC Inspector	
			Chief E	ng Chief Eng	Da	ite				
-,-,-	-	900								